

Work Order ID 81417

81417

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March-14-12 7:52:19 AM

Item ID: D2344 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Litter Deck Plate, 350
 Start Date: 13/03/2012 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 27/03/2012 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/14 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2344	Rev F

100 0.00

100

FLOW WATERJET

Waterjet Memo 0.00

FLOW CNC Waterjet

1-Cut as per dwg
 prog rev: F
 dwg rev: F

2024 063

2-deburr as required

110 0.00

QC2- Inspect parts off machine FAI/FAIB

110

QC Memo 0.00

Quality Control

1312-5-19

1312-5-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D2344

Accept

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Revision ID:

Item Name: Litter Deck Plate, 350

Stop ***NS2***

Start Date: 13/03/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 8.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

Small Fab

0.00

130

Small Fab

Memo

0.00

Small Fab

1-Deburr sharp edges 2-Countersink holes per Dwg D2344

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

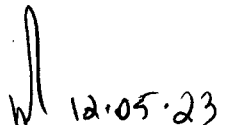
Memo

0.00

Quality Control



10



W/O: 81417		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2344 PAR #: _____ Fault Category: Sm Tab NCR: Yes No QA: ~~not~~ Date: 12/05/30
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: ✓ Date: 12/5/31

NCR: 12-14164		WORK ORDER NON-CONFORMANCE (NCR) 27.99						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/05/23	130	1 part c/nk to deep RC operation error process 12A	<u>S</u> 12/05/23 057442	Scrap + destruction W/o replace	<u>S</u> 12/05/23	<u>nl</u> 12.05.23	<u>S</u> 12/05/23 057442	<u>S</u> 12/05/23

NOTE: Date & initial all entries

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Item ID: D2344

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Litter Deck Plate, 350

Stop ***NS2***

Start Date: 13/03/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150 Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

10 7/6/12-5-23

155 QC7-Inspect Chemical Conversion Coat

0.00

155

QC

Memo

0.00

Quality Control

10X ϕ M-L 12/05/24

160 Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

160

Powdercoat

Memo

0.00

Powder Coating

START TIME: 8:00 OVEN TEMPERATURE:

FINISH TIME:

3200F

8:30

10X ϕ M-L 12/05/24

W117338

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00							
Quality Control									

10 x 6 all 12/06/12f

180	Identify as per dwg & Stock Location <i>247</i>	0.00							
180									
Packaging	Memo	0.00							
Packaging									

Per 12/05/12 (10)

190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

12/15/30
W 12/05/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 81417

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Parent Item: D2344

D2344

Parent Item Name: Litter Deck Plate, 350

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:D00.06.26Removed P/O for powder coatEC
IPP Rev:E 07-07-04 Asper Rev F JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.063

Purchased

No

100

sf

171.9000

0.745

6.273684

9, ①

B12-5-19

M2024T3S 063

**

2024-T3 .063 sheet

Location

Loc Qty

Loc Code

MAT022

171.9

119916

171.9

121197

121197

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DART AEROSPACE LTD		Work Order:	81417
Description: Litter Deck Plate Kit (350)		Part Number:	D2344
Inspection Dwg: D2344 Rev: F		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.223	+/-0.010	6.220	X		V R2	
5.598	+/-0.010	5.600	2		V	
4.869	+/-0.010	4.873	2		V	
3.889	+/-0.010	3.892	2		V	
3.096	+/-0.010	3.100	2		V	
2.891	+/-0.010	2.903	2		V	
16.973	+/-0.010	16.973	2		T Bol	
0.450	+/-0.010	.455	2		V	
4.423	+/-0.010	4.426	2		V	
4.723	+/-0.010	4.731	2		V	
1.202	+/-0.010	1.204	2		V	
5.869	+/-0.010	5.871	2		V	
4.654	+/-0.010	4.660	2		V	
Ø0.656	+0.005/-0.000	.655	2		V	
1.888	+/-0.010	1.890	2		V	
2.285	+/-0.010	2.288	2		V	
2.683	+/-0.010	2.690	2		V	
Ø0.171	+0.005/-0.000	.172	2		V	
3.491	+/-0.010	3.495	2		V	
Ø0.191	+0.005/-0.000	.190	2		V	
3.123	+/-0.010	3.130	2		V	
1.975	+/-0.010	1.975	2		V	
Ø0.128	+0.005/-0.001	.128	2		V	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 12-5-19	Date: 12/05/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue P/O D350-616-015	KJ/JLM	
B	07.07.17	Dwg Rev. updated	KJ/JLM	
C	07.09.06	Dimensions updated per Dwg. Rev. F	KJ/JLM	B

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